

## TRANSLATION

1. A method of making a conduit (1) for vibration-stressed piping systems, in particular as a motor-vehicle exhaust pipe, from a preshaped strip (2 or 3), in particular a metal strip, that is helically wound with bellows-like turns (4 or 22), the wound-together layers formed by a strip width having singly hooked-together or multilayer interlocked edges (9; 19) joined by interfitting, welding, or a similar joining process, the strip (2 or 3) being preshaped by at least one roller pair outside the plane and being thereby deflected into an arcuate path with in both stretched and compacted condition fold height (h1 and h2) of the folds (4 and 22) equal to a multiple of the strip thickness, characterized in that the folds (4 and 22) are made by connecting the edges of webs (5a and 5b) projecting radially from the trailing edge (10) of one turn and the leading edge (11) of another turn.

2. The method according to claim 1, characterized in that the web edges are deformed and joined together at peaks (15).

3. The method according to claim 1, characterized in that the web edges are thermally joined together at peaks (15).

4. The method according to one of claims 1 to 3, characterized in that a bell-shaped inner fold (22) is wound in a valley of an outer fold (4) with diametrally extending webs (5b) projecting from a common bridge and connecting web (21).

5. The method according to claim 4, characterized in that upper free web edges of the bell-shaped inner fold (22) are connected to adjacent web edges of the outer fold (4).

6. A conduit (1) for vibration-stressed piping systems, in particular as a motor-vehicle exhaust pipe, made from a preshaped strip (2 or 3), in particular a metal strip, that is helically wound with bellows-like turns (4 or 22), the wound-together layers formed by a strip width having singly hooked-together or multilayer interlocked edges (9; 19) joined by interfitting, welding, or a similar joining process, the folds (4 and 22) having heights (h1 and h2) equal to a multiple of a strip thickness, produced by the method of claims 1 to 5, characterized in that each fold (4) is formed by webs (5a and 5b) projecting radially from the turns and having free edges that are connected gas-tight together at the peak (15).

7. The conduit according to one of claim 6,  
characterized in that  
a tube-base forming strip (3) is formed with bell-shaped folds (22)  
that are each fitted in a fold of the other strip (2), free web  
edges of the outer fold (4) being joined at the peak (15) with the  
free edges of the inner adjacent webs (5b) of the bell-shaped fold  
(22) that covers the valley (16) of the outer fold (4) with a  
connecting region (21) between its webs (5b).

8. A conduit (1) for vibration-stressed piping systems,  
in particular as a motor-vehicle exhaust pipe, made from a  
preshaped strip (2 or 3), in particular a metal strip, that is  
helically wound with bellows-like turns (4 or 22), the wound-  
together layers formed by a strip width having singly hooked-  
together or multilayer interlocked edges (9; 19) joined by  
interfitting, welding, or a similar joining process, the folds (4  
and 22) having heights (h1 and h2) equal to a multiple of a strip  
thickness, produced by the method of claims 1 to 5,  
characterized in that  
each fold (4) is formed from a turn layer with a peak (15) of a  
preshaped closed turn and has a gas-tight interlock connection (9  
or 19).